

# Work Order ID 81895

\*81895\*

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Tuesday, March 20, 2012 11:29:26 AM

Item ID: D2429-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Spring Clip Assembly  
 Start Date: 3/20/2012 Start Qty: 6.00 \*6\* (12)  
 Required Date: 3/26/2012 Req'd Qty: 6.00 \*6\* Cust Item ID:  
 Reference: Customer:

Approvals: Process Plan:                      Date: 3-20-12 Tooling:                      Date:                      Run Start \*NR1\*  
 QC:                      Date:                      SPC (Y/N):                      Date:                      Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2429	Rev C1								

100

0.00

\*100\*

Waterjet

FLOW CNC Waterjet

304.040"

FLOW WATER JET

Memo

0.00

1-Cut as per Dwg D2429\*\*\*\*\*Make 2 parts per -041  
 assembly\*\*\*\*\* Dwg Rev: C Prog Rev: C

2-Deburr if necessary

12 0 Jm 12-6-11

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Quality Control

Memo

0.00

12 0 Jm 12-6-11

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Quality Control

Memo

0.00

12 W 12-6-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D2429-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Spring Clip Assembly  
 Start Date: 3/20/2012 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 3/26/2012 Req'd Qty: 6.00 \*6\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00				12			SA 12/06/14
*130*	Small Fab	0.00							
Small Fab	Memo								
Small Fab	1-Deburr 2-Bend D2429-1 as per Dwg D2429								
140	QC5- Inspect part completeness to step on W/O	0.00							
*140*		0.00							
QC	Memo								
Quality Control									
150		0.00							
*150*	Small Fab	0.00							
Small Fab	Memo								
Small Fab	Assemble D2429-041 as per Dwg D2429								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81895

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Tuesday, March 20, 2012 11:29:26 AM

Item ID: D2429-041 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Spring Clip Assembly  
Start Date: 3/20/2012 Start Qty: 6.00 \*6\* Cust Item ID:  
Required Date: 3/26/2012 Req'd Qty: 6.00 \*6\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC5- Inspect part completeness to step on W/O	0.00							
*160*		0.00							
QC	Memo								
Quality Control									

170	Identify as per dwg & Stock Location	0.00							
*170*		0.00							
Packaging	Memo								
Packaging									

180	QC21- Final Inspection - Work Order Release	0.00							
*180*		0.00							
QC	Memo								
Quality Control									

12/6/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, March 20, 2012 11:29:30 AM

Page 1

Work Order ID: 81895

**\*81895\***

Parent Item: D2429-041

**\*D2429-041\***

Parent Item Name: Spring Clip Assembly

Start Date: 3/20/2012

Required Date: 3/26/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP D02.03.06Added note at step 7 NG  
IPP Rev:E Now on Waterjet 06-06-13 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD6L <b>*AN960JD6L *</b> Washer		Purchased	No			110	Each	682.0000	2	12			
									**	(6)	FF 12-06-10		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST337A		682							
				5519		682							
M304S20GA <b>*M304S20GA*</b> 304/316 .040 Sheet		Purchased	No			150	sf	163.6165	0.0068	12 0.042947			
									**	(6)	Jm 12-6-11		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		163.6165							
				116623		0.2							
				117933		27.3442							
				118400		21.1723							
				118964		36.5							
				119346		29.8							
				120604		48.6							
MS20470AD4-5 <b>*MS20470AD4-5*</b> Rivet, Universal Head		Purchased	No			150	Each	2,909.000	1	120604 6			
									**	(6)	FF 12-06-18		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST319		2909							
				118405		1256							
				120142		1653							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

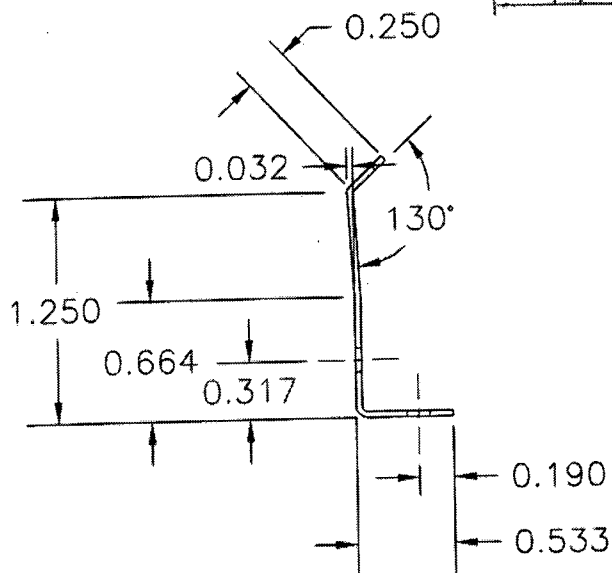




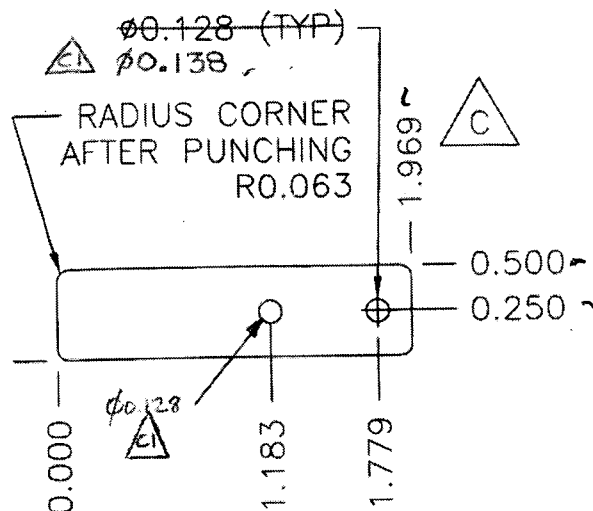


DESIGN	KE	DRAWN BY	RF	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2429
				REV. C SHEET 1 OF 1
DATE	00.06.26	TITLE	SPRING CLIP	SCALE 1:1
A	95.07.21	NEW ISSUE		
B	97.10.09	ADDED ASSEMBLY		
C	00.06.26	1.969 WAS 2.100; 0190 WAS 0.321		
C1	<i>UP</i> 01.03.27	$\phi 0.138$ WAS $\phi 0.128$		

RELEASED  
00.06.27 *[Signature]*

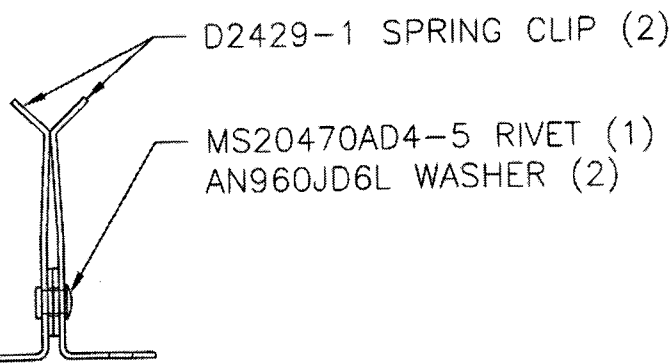


D2429-1 SPRING CLIP



D2429-1 FLAT PATTERN

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 81895



D2429-041 SPRING CLIP ASSEMBLY

MATERIAL: AISI 304/316 SS 0.040 THICK 0.50 WIDE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSION ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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